

Work Order ID 63550

Thursday, November 04, 2010 10:02:51 AM

Page 1

Item ID: D3067-1

Accept

Revision ID:

Item Name: End Plate

Start Date: 11/4/2010 Start Qty: 40.00

Required Date: 11/19/2010 Req'd Qty: 40.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3067

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3067

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B10-11-19

(108)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-11-19

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

count
(108)

S 10/11/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 63550

Thursday, November 04, 2010 10:02:51 AM

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Item ID:	D3067-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	End Plate					
Start Date:	11/4/2010	Start Qty:	40.00		Cust Item ID:	
Required Date:	11/19/2010	Req'd Qty:	40.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE Memo Bend as per Dwg D3067	0.00 0.00				<u>108</u>			
			JB 10/11/24						
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>108</u>			
			D 10/11/24						
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo *** STOCK IN STEP CELL***	0.00 0.00				<u>108</u>			
			10.12.03 10.12.03						

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Item ID: D3067-1

Accept

Revision ID:

Item Name: End Plate

Start Date: 11/4/2010 Start Qty: 40.00

Required Date: 11/19/2010 Req'd Qty: 40.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/06

MF
10-12-06

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, November 04, 2010 10:02:55 AM

Page 1

Work Order ID: 63550

Parent Item: D3067-1

Parent Item Name: End Plate



Start Date: 11/4/2010

Required Date: 11/19/2010

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: ☐ 03.01.21 Remove step 6 (Deburr) KJ
IPP Rev:B Now on Water jet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.063

Purchased

No

100

sf

165.6700

0.0625

2.631579

689



1810-11-19

5052-H32 .063 Sheet

Location

Loc Qty

Loc Code

MAT

159.5

114322

159.5

MAT22

6.17

112442

6.17

112442

108

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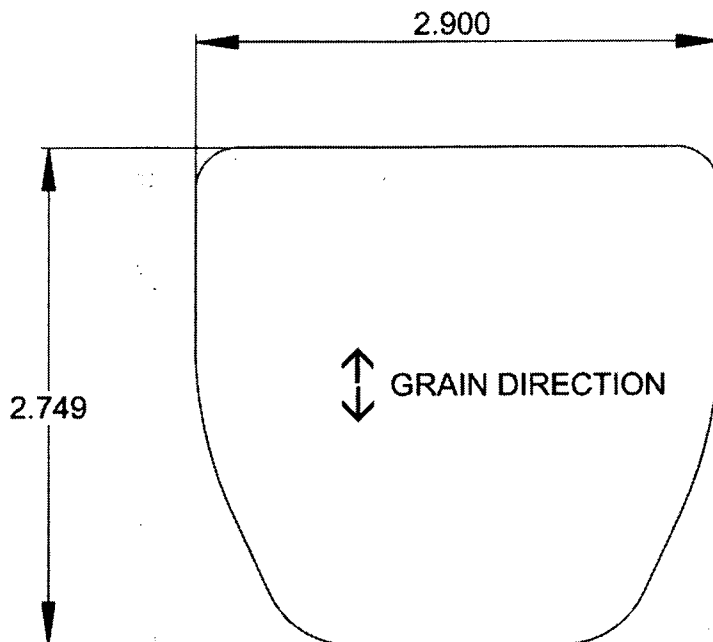
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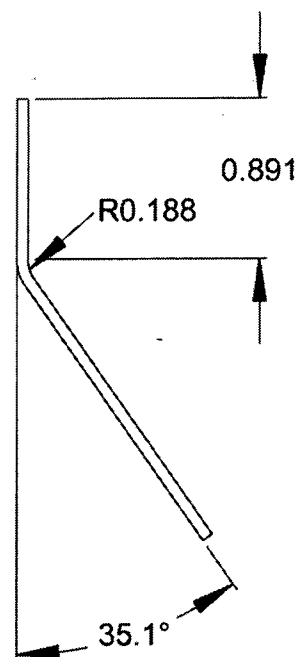


DESIGN <i>ap</i>	DRAWN BY <i>ap</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>ap</i>	APPROVED <i>ap</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63550

BS10-11-04

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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